

Date: Wednesday, 2/15/2006 3:50:17 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SADDLE FITTING, FWD (OUTBOARD/INBOARD)  
 Job Number : 25860  
 Estimate Number : 10531  
 P.O. Number : N/A Part Number : D2572  
 This Issue : 2/15/2006 S.O. No. : N/A Drawing Number : D2572 REV DE  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : MACHINED PARTS Drawing Revision : DE  
 Previous Run : 25831 Material : N/A  
 Due Date : 3/10/2006 Qty: 6 Um: Each  
 Written By : SEE COMMENT BELOW  
 Checked & Approved By : 06.02.16  
 Comment : Est: 1 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572KJ

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D6101005 7075-T7351 8.25X5.0X2.5



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

7075-T7351 8.25X5.0X2.5

Make from D6101-005 billet for D2572

Ensure that grain is along 5.00" length

Batch No: B 24069

x 6

En 06/03/18

(6)

2.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Program Batch No 325860 Double check by: J.L.

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets

2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets

4-Deburr and remove all machining marks

5-Tumble to remove shap edges.

S.G.

06/03/25

6

3.0 MILLING CONV. CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Machine keyway as per dwg D2571 & D2572

S.G.

06/03/25

6

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/03/30  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 2/15/2006 3:50:17 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, FWD (OUTBOARD/INBOARD)

Job Number: 25860

Part Number: D2572

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.G. 06/03/25 6

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SD 06-03-26

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

a.m 06-03-27 (6)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

DL 06/03/28 (6)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

PC 4/3/29 (6)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 479

PC 4/3/29 (6)

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

D 06/03/30 (6)

Job Completion



u 06-03-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	<b>25860</b>
<b>Description:</b> Saddle, Fwd Inboard	<b>Part Number:</b>	<b>D2572</b>
<b>Inspection Dwg:</b> D2572 Rev. E		<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	0.438	0.438	0.438	0.438		
B	1.745	1.755		1.745	1.745	1.746	1.745		
C	3.495	3.505		3.498	3.495	3.495	3.496		
D	1.745	1.755		1.745	1.745	1.746	1.745		
E	7.990	8.010		8.004	8.003	8.003	8.001		
F	0.490	0.510		0.497	0.498	0.496	0.501		
G	0.257	0.262	DT8683	0.257	0.257	0.257	0.257		
H	0.375	0.380	DT8684	0.375	0.375	0.375	0.375		
I	0.490	0.510		0.500	0.497	0.497	0.497		
J	1.174	1.184		1.177	1.178	1.178	1.178		
K	0.558	0.578		0.569	0.567	0.565	0.566		
L	1.174	1.184		1.177	1.178	1.178	1.178		
M	1.490	1.500		1.496	1.493	1.493	1.493		
N	2.495	2.505		2.496	2.495	2.497	2.495		
O	3.869	3.879		3.872	3.872	3.873	3.873		
P	0.115	0.135		0.129	0.127	0.127	0.127		
Q	0.115	0.135		0.130	0.130	0.130	0.130		
R	0.240	0.260		0.252	0.252	0.251	0.255		
S	0.115	0.135		0.119	0.121	0.122	0.121		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.235	0.236	0.237	0.238		
W	0.115	0.135		0.122	0.125	0.124	0.123		
X	0.307	0.312		0.310	0.310	0.310	0.310		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.360	0.360	0.365	0.362		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.625	0.623	0.622	0.622		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.249	0.249	0.245	0.248		
AE	1.375	1.395		1.385	1.387	1.387	1.386		
AF	0.115	0.135		0.130	0.130	0.130	0.130		
AG	0.240	0.280		0.260	0.260	0.265	0.260		
AH	0.240	0.260		0.246	0.248	0.247	0.251		
AI	2.000	2.020		N/A	N/A	N/A	N/A		
AJ	0.023	0.043		0.030	0.030	0.030	0.030		
Accept/Reject									

Measured by:	EP
Date:	06/03/24

Audited by:	SH
Date:	06.03.26

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 25860
<b>Description:</b> Saddle, Fwd Inboard	<b>Part Number:</b> D2572
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D	1.745	1.755		1.746	1.747				
E	7.990	8.010		8.005	8.005				
F	0.490	0.510		0.498	0.499				
G	0.257	0.262	DT8683	0.257	0.257				
H	0.375	0.380	DT8684	0.375	0.375				
I	0.490	0.510		0.501	0.500				
J	1.174	1.184		1.173	1.177				
K	0.558	0.578		0.566	0.567				
L	1.174	1.184		1.177	1.177				
M	1.490	1.500		1.494	1.494				
N	2.495	2.505		2.496	2.496				
O	3.869	3.879		3.874	3.874				
P	0.115	0.135		0.128	0.128				
Q	0.115	0.135		0.130	0.130				
R	0.240	0.260		0.253	0.252				
S	0.115	0.135		0.120	0.121				
T	0.178	0.198		0.188	0.188				
U	2.940	2.980		2.960	2.960				
V	0.230	0.250		0.235	0.234				
W	0.115	0.135		0.124	0.124				
X	0.307	0.312		0.310	0.310				
Y	0.760	0.765		0.760	0.760				
Z	0.352	0.372		0.365	0.365				
AA	0.470	0.530		0.500	0.500				
AB	0.615	0.635		0.623	0.625				
AC	0.053	0.073		0.063	0.063				
AD	0.240	0.260		0.248	0.248				
AE	1.375	1.395		1.387	1.387				
AF	0.115	0.135		0.130	0.130				
AG	0.240	0.280		0.260	0.260				
AH	0.240	0.260		0.251	0.250				
AI	2.000	2.020		N/A	N/A				
AJ	0.023	0.043		0.038	0.038				
Accept/Reject									






Measured by:	en
Date:	06/03/25

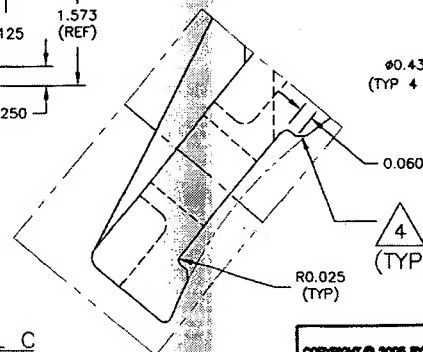
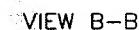
Audited by:	SD
Date:	06/03/26




Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

05.12.06 ~~11~~



	ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
	CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
	CHAMFER 0.063 x 45° ALL AROUND
	CHAMFER 0.033 x 45° (SEE DETAIL C) 



E	05.07.13	ADD CHAMFER ON RIDGE NOTE 4
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE
DESIGN DS		DRAWN BY PH
CHECKED 		APPROVED 
DATE 05.07.13		TITLE INNER FWD SADDLE
		 <b>DART AEROSPACE LTD.</b> MARKHAM, ONTARIO, CANADA
		REV. SHEET 1 OF 2

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**DART**

**DART AEROSPACE LTD.**  
WARRINGTON, CHESHIRE, ENGLAND

DRAWING NO  
D2572

REV.  
ET 1 OF

TITLE	INNER FWD SADDLE
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SCAL

2

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